

Page 1

Wednesday, July 14, 2010 9:17:32 AM Accept Item ID: D3859-041 Setup Start **Revision ID:** Stop Item Name: Wearplate **Start Date:** 7/14/2010 Start Qty: 6.00 **Cust Item ID:** Required Date: 7/22/2010 Req'd Qty: 6.00 **Customer:** Reference: Run Start Date/6-7-14 **Process Plan:** Approvals: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code **Qty Qty** Number Stamp **Draw Nbr Revision Nbr** 100 0.00 FLOW WATER JET Waterjet 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D3859 □Dwg Rev Deburr if necessary 334.663 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1R10-7-21 0.00 Memo Quality Control 120 QC8- Inspect parts - second check Sigloslas Memo Quality Control

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
							Frod Migr					
<del></del>								-				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:	Date:					
	Re	esolution:	Dispositio	n:	_ QA: N/C Clo	sed:	Date: _					
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NCR	)						
DATE	CTED	Description of NC	of NC Corrective Action			Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
<del> </del>												
-												
			*									
	1				I	1						

#### Work Order ID 60560

Wednesday, July 14, 2010 9:17:32 AM



Page 2

Item ID:

D3859-041

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 7/22/2010

Wearplate

7/14/2010

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

Δn	prova	le•
$\Delta D$	μιυνα	15.

Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling:

Operation

Description

Large Fab

0.00

0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Tool # Plan

Code

Run

Accept

**Qty** 

Stop

Reject

B 10-8-11

Qty



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

130

Large Fab Large Fab

Memo

Memo

Memo

Date:\_\_\_\_\_

1-Weld D3009-3 cups as per dwg D3859□ A/R 316L stainless steel rod Batch: M 10g/60 □2-Weld hard facing as per Dwg D3859 □ A/R 2059B Hard Coat rod Batch: M / 14 818

DT9462 for welding\*\*\*\*\*

140

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

0.00

150

Quality Control

QC5- Inspect part completeness to step on W/O

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								-			
·	·	·									
							İ				
							,				
		PAR #:	Fault Ca	tegory:	NCR: Y	es No	DQA:	Date: _			
Resolution:			Disposit	ion:	QA: N/C	Closed:	-	Date:			
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC			ective Action Section B  Action Description Sign &			Approval	Approval		
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector		

#### Work Order ID 60560

Wednesday, July 14, 2010 9:17:32 AM



Page 3

Item ID:

D3859-041

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Wearplate

**Start Date:** 7/14/2010

Required Date: 7/22/2010

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

**Tooling:** 

Date: Date: Run

Start

Stop



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

**Work Center ID** 160

Sequence ID/

Powdercoat Powder Coating

Memo

Description /1 1(2588 Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

2:300 \(\tau\) OVEN TEMPERATURE:

0.00

START TIME: <u>3 `OO⊃</u> ENISH TIME:

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

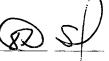
180

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00



Memo

W/O: WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cated	lorv:	NCR: Yes	No DQ	 <b>A</b> :	Date:	
			Disposition:						
NCR:		·. ·	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	0750	Description of NC	Corrective Action Sec			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Sect	Section C	Chief Eng	QC Inspector
						:			
	1				ļ				

#### Work Order ID 60560

Wednesday, July 14, 2010 9:17:32 AM



Page 4

Item ID:

D3859-041

Accept



Setup Start

Stop

Stop



**Revision ID:** 

**Item Name: Start Date:** 

Wearplate

7/14/2010

Start Qty: 6.00

Required Date: 7/22/2010 Req'd Qty: 6.00



Date:\_\_\_\_\_

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Operation

Description

Date:\_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Start Run

Qty

QC:

Sequence ID/

Work Center ID

190

Memo

QC21- Final Inspection - Work Order Release

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Quality Control

0.00

0.00

Dart Aeı	ospace	Ltd							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	}								
					1				
Part No	<b>:</b>	PAR #:	Fault Cate	gory:	NCR: Ye	s No <b>D</b>	QA:	Date: _	
	Re	solution:						Date: _	
NCR:		•	WORK ORD	ER NON-CONFORMA	ANCE (NO	CR)			
		Description of NC		Corrective Action Section B		Ver	ification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&∣ <sub>Se</sub>	ection C	Chief Eng	QC Inspector
· <del>* * * * *</del>				<u> </u>			·		

### **Picklist Print**

Wednesday, July 14, 2010 9:17:36 AM

Work Order ID: 60560

Parent Item:

D3859-041

Parent Item Name: Wearplate



**Start Date:** 7/14/2010

Required Date: 7/22/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

_				
С.				~ ~
	۱m	me	ent	€.

IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	 	Purchased	No			100	sf	51.5039	0.85	5.1	6.8 18 10-	7-24	-
D3009-3		Manufactured	No	<u>Location</u> MAT	111323 114799	51.50389 51.50389 51.5038	9474	<b>Loc Code</b> 329.0000	_	1479 36		® -8-1	<i>(</i>
Cup				<u>Location</u> WA	42377	<u>Loc (</u>	Otv 329 329	Loc Code		48		<u> </u>	.(

rospace L	td							
		W	ORK ORDER CHANG	GES				·
STEP	PR	OCEDURE CHA	NGE	By	/ Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQA:	Date: _	
Resolution:		Disposition: (		QA: N/	QA: N/C Closed:			
		WORK ORD	ER NON-CONFORM	IANCE (N	ICR)			
STEP	Description of NC Section A	Initial Chief Eng		Si	gn &	<b>/erification</b> Section C	Approval Chief Eng	Approval QC Inspector
	STEP STEP	:PAR #: Resolution:  STEP Description of NC Section A	STEP PROCEDURE CHA  :PAR #:Fault Cate  Resolution:Dispositio  WORK ORD  STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE  :PAR #: Fault Category: Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Section A Corrective Action Description Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng	STEP PROCEDURE CHANGE By  PROCEDURE CHANGE By  PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Y  Resolution: Disposition: QA: N/C  WORK ORDER NON-CONFORMANCE (NOT CONFORMANCE)  STEP Description of NC	STEP PROCEDURE CHANGE By Da  :PAR #: Fault Category: NCR: Yes No Resolution: Disposition: QA: N/C Close  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Initial Chief Eng Chief E	STEP PROCEDURE CHANGE By Date Qty  :PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Date Chief Eng Ch	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr  :PAR #: Fault Category: NCR: Yes No DQA: Date: _  Resolution: Disposition: QA: N/C Closed: Date: _  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

DART AEROSPACE LTD	Work Order:	40560
Description: Wearplate	Part Number:	D3859-1
Inspection Dwg: D3859 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

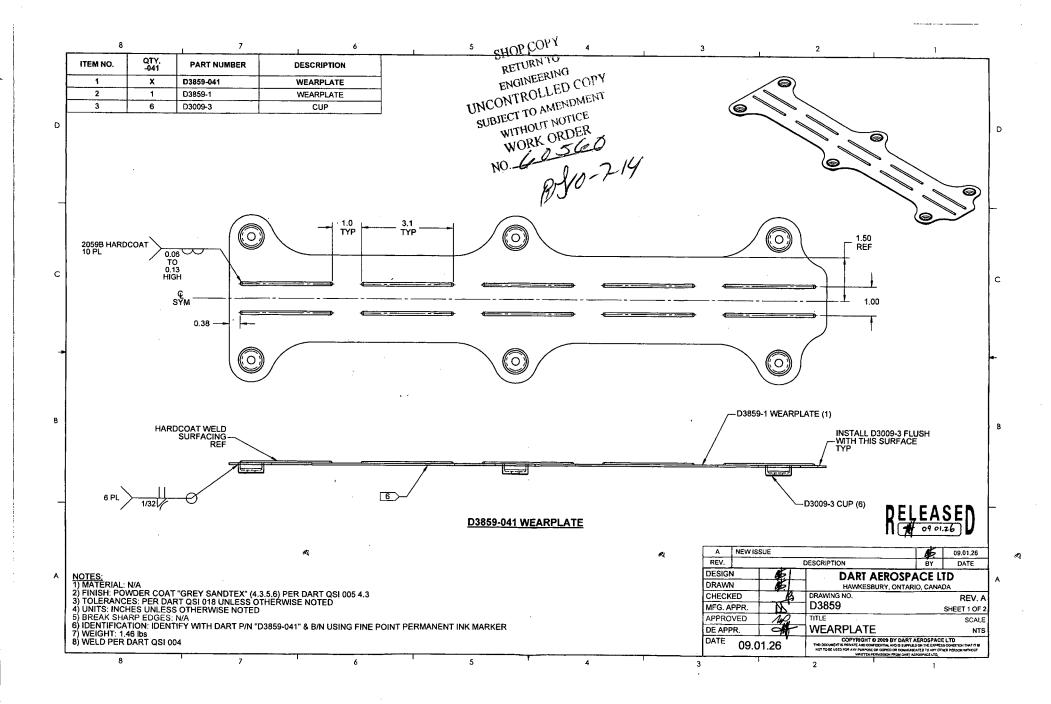
X	First Article		Prototype
---	---------------	--	-----------

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Com	ments
Dimension		Dimension			_		
Ø0.879	+0.010/-0.001	.878	*		VENN 1803	L	
0.75	+/-0.030	746	*		V		
4.250	+/-0.010	4.749	<b>&gt;</b>		V	·	
3.00	+/-0.030	3,006	*		V		
5.75	+/-0.030	5.747	×		V		
9.000	+/-0.010	9,000	٧		<b>*</b>		
1.50	+/-0.030	1.50	>		V		
20.40	+/-0.030	20.896	<b>W</b>		V		
0.063	+/-0.010	30. <b>3</b> 90	X		V		
						€.	
				<del></del>			
· · · · · · · · · · · · · · · · · · ·					-		
		<del></del>					
easured by: 172		Audited by:			Prototype App	oroval:	N/A
	(N) - 21		introl	$\overline{}$		€Date:	N/A

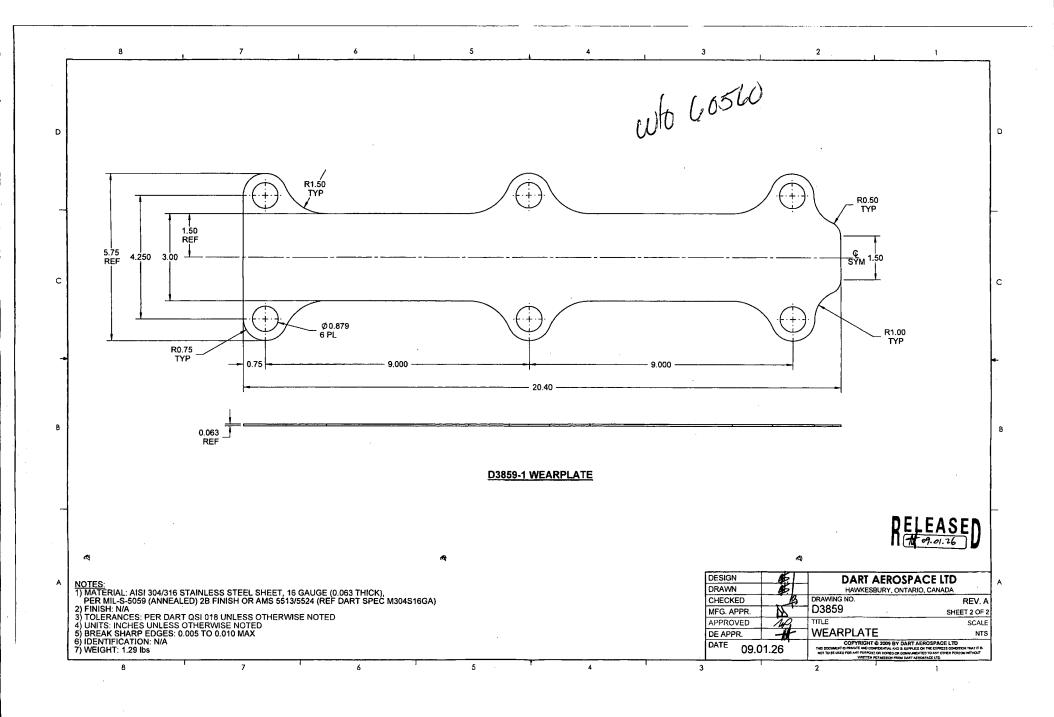
Measured by:	Audited by: S	Prototype Approval:	N/A
Date: (0-7-71	Date: 10/06/03	€Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	09.05.20	New Issue	P/O D3859-041	KJ of	<i>X</i>

W/O:		WORK ORDER CHANGES									
DATE	STEP	PF	Ву	Date	Qty	Approval Chief Eng / Prod Mgr					
			PROCEDURE CHANGE  By Date Qty Approval Chief Eng / Prod Mgr QC Inspector  PAR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B Verification Approval Approval Approval								
							3				
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date: _			
Re		esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	<del></del>		
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCF	<b>(</b> )					
DATE	STEP	Description of NC							Approval		
1		Section A				Sectio	in C	Chief Eng	QC inspector		
					i.						
	1										
			·								



Dart Ae	rospace	Ltd								
W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	STEP PROCEI		IANGE	GE By		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									ing to the second of the secon	
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes	No <b>DQ</b>	<b>4</b> :	_ Date: _	
	Re	esolution:	Disposition: C		QA	A: N/C Closed:			Date:	
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
				-	•					



Dail AC	Ospace								N. a r
W/O:			WORK ORDER (	CHANGES					•
DATE	STEP	PI	ROCEDURE CHANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						ē
			J. 1980	·					
Part No	):	PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date:	
	F	esolution:	Disposition:	QA: N	I/C CI	osed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Annroval			
	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector			
	!							-			
						. 5					
						1.					
		, <u></u>									